

Date: Tuesday, 11/13/2007 1:24:08 PM  
User: Kim Johnston

*Split*  
8/07/10/20

## Process Sheet

|                       |   |  |                  |                         |  |  |  |  |
|-----------------------|---|--|------------------|-------------------------|--|--|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services             |  | Drawing Name     | : ACCESS PANEL ASSEMBLY |  |  |  |  |
| Job Number            | : 35649 <i>2</i>                                  |  |                  |                         |  |  |  |  |
| Estimate Number       | : 13008   |  |                  |                         |  |  |  |  |
| P.O. Number           | : N/A   |  | Part Number      | : D3245041              |  |  |  |  |
| This Issue            | : 11/13/2007                                      |  | S.O. No.         | : N/A                   |  |  |  |  |
| Prsht Rev.            | : NC  |  | Project Number   | : D3245 REV B           |  |  |  |  |
| First Issue           | : N/A   |  | Drawing Revision | : N/A                   |  |  |  |  |
| Previous Run          | : 34551   |  | Material         | : B                     |  |  |  |  |
| Written By            | :   |  | Due Date         | : 11/28/2007            |  |  |  |  |
| Checked & Approved By | :   |  | Qty:             | 8 Um: Each              |  |  |  |  |
| Comment               | : Est Rev:A New Issue 07-09-11 JLM Verified By:EC |  |                  |                         |  |  |  |  |
|                       | Est Rev:b ECN 1052 07-10-31 DD verified by: EC    |  |                  |                         |  |  |  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :   |                    |
|---------|-----------------------|---|--------------------|
| 1.0     | PACKAGING 1           | PACKAGING RESOURCE #1                                       |                    |
|         |                       | Comment: PACKAGING RESOURCE #1                              |                    |
|         |                       | Pick Packing Kit  |                    |
| 2.0     | D32451                | Panel   |                    |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)   |                    |
|         |                       | Panel   |                    |
|         |                       | Batch: <u>B35656</u>  |                    |
| 3.0     | D32455                | Angle Plate   |                    |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)   |                    |
| Job     |                       | Angle Plate   |                    |
|         |                       | Batch: <u>B35047 x6</u>                                     | <u>AS 07/12/14</u> |
| 4.0     | 235018C3Y             | RIGID RECEPTACLE  |                    |
|         |                       | Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)  |                    |
|         |                       | RIGID RECEPTACLE  |                    |
|         |                       | Batch: <u>M106037</u>                                       | <u>AS 07/12/14</u> |
| 5.0     | MS20427M33            | Rivet   |                    |
|         |                       | Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s) |                    |
|         |                       | Rivet   |                    |
|         |                       | Batch: <u>M106037 M10594 x8</u>                             | <u>AS 07/12/14</u> |

## Process Sheet

Customer: CU-CAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 35649

Part Number: D3245041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS20615M33

Rivet

Comment: Qty.: 9.0000 Each(s)/Unit Total : 54.0000 Each(s)  
Rivet

*NOT for consumption*  
M15235X54  
106277 880712/19 86

7.0 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part# and batch# using fine point ink marker and Stock

Location: ST183

*ST183*  
AS0712/20 76

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

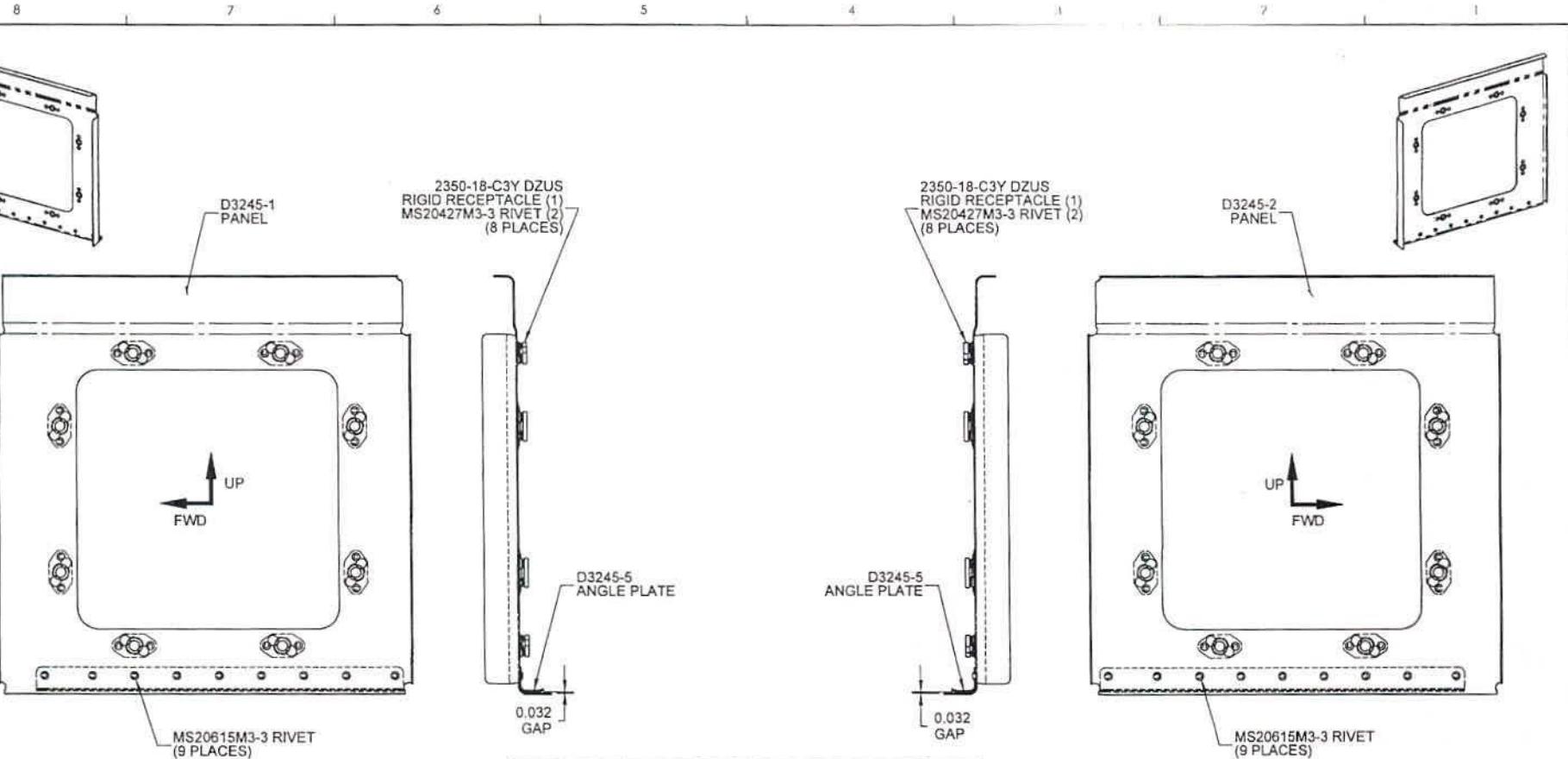
*AS0712/20*  
Dart/12/21

Completion



*2007/12/21*

*U*



D3245-041 ACCESS PANEL ASSEMBLY

| QTY<br>-041 | QTY<br>-042 | P/N         | DESCRIPTION               |
|-------------|-------------|-------------|---------------------------|
| X           |             | D3245-041   | ACCESS PANEL ASSEMBLY, LH |
| X           |             | D3245-042   | ACCESS PANEL ASSEMBLY, RH |
| 1           |             | D3245-1     | PANEL                     |
| 1           | 1           | D3245-2     | PANEL                     |
| 1           | 1           | D3245-5     | ANGLE PLATE               |
| 8           | 8           | 2350-18-C3Y | DZUS RIGID RECEPTACLE     |
| 16          | 16          | MS20427M3-3 | RIVET                     |
| 9           | 9           | MS20615M3-3 | RIVET                     |

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.83 lbs

RELEASED  
 07.10.02

WORK IN PROGRESS  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
 ENGINEERING DRAWING

D3245-042 ACCESS PANEL ASSEMBLY

|            |   |  |              |
|------------|---|--|--------------|
| B          | REMOVE Ø0.204 HOLES FROM D3245-1/-2/-3. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING | MB   | 07.10.02     |
| A          | NEWISSUE  | RF   | 04.01.27     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | <i>PH</i>   | DART AEROSPACE LTD   |              |
| DRAWN      | <i>PH</i>   | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | <i>PH</i>   | DRAWING NO.  | REV. B       |
| MFG. APPR. | <i>DS</i>   | D3245  | SHEET 1 OF 7 |
| APPROVED   | <i>AS</i>   | TITLE  | SCALE        |
| DE APPR.   | <i>AS</i>   | ACCESS PANEL ASSEMBLY  | 1:2.5        |
| DATE       | 07.10.02  | COPYRIGHT © 2004 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |